

17-4 H900 Ø.500

Work Order ID 129783

129783

Page 1

February-23-15 10:21:43 AM

Item ID: D4804-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut
 Start Date: 2/23/15 Start Qty: 9.00 *9* Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 9.00 *9* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-02-24 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4804	C

100 DOOSAN LATHE 0.00
 100
 Doosan Memo 0.00
 Doosan Lathe 1- Turn as per Folio FB274
 Rev: N/A & Dwg D4804 Rev: C

2- Deburr

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control

9 _____ JL 15-3-6

9 _____ JL 15-3-6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									DAS
QC	Memo	0.00							08
Quality Control									9-89

130	Outsource process - NDT per QSI038 4.1	0.00							
130									
Outsource2	Memo	0.00							
Outsource process - NDT	ISSUE P/O : 27868								
	C OF C IS REQUIRED								

140	Receive & Inspect for Damage & Mat'l Certs	0.00							
140									
Packaging	Memo	0.00							
Packaging									

B. 15/03/09

CL 15/03/24 (9)

IX SPIS-03-24

DQA: _____ Date: _____



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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00				(9)			DAS 38 9-89
150									
QC	Memo	0.00							
Quality Control									MAR 24 2015
160	Identify as per dwg & Stock Location: <u>5/128</u>	0.00				9			DAS 27 9-89
160									
Packaging	Memo	0.00							
Packaging									MAR 25 2015
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									MCS 15-03-25 ME 15-3-25

DQA: _____ Date: _____



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Picklist Print

February-23-15 10:21:43 AM

Page 1

Work Order ID: 129783

129783

Parent Item: D4804-1

D4804-1

Parent Item Name: Strut

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP REV:A NEW ISSUE 14-01-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M174PH-H900R0.500

Purchased

No

f

124.1320

9.388421

M174PH-H900R0 500

**

SL 15-36

17-4SS H900 ROUND BAR 0.500

Location

Loc Qty

Loc Code

MAT030

3.112

M129892

3.112

MAT031

1.02

M128314

1.02

ST202

120

M131473

120

9.4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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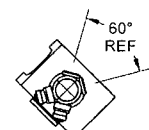
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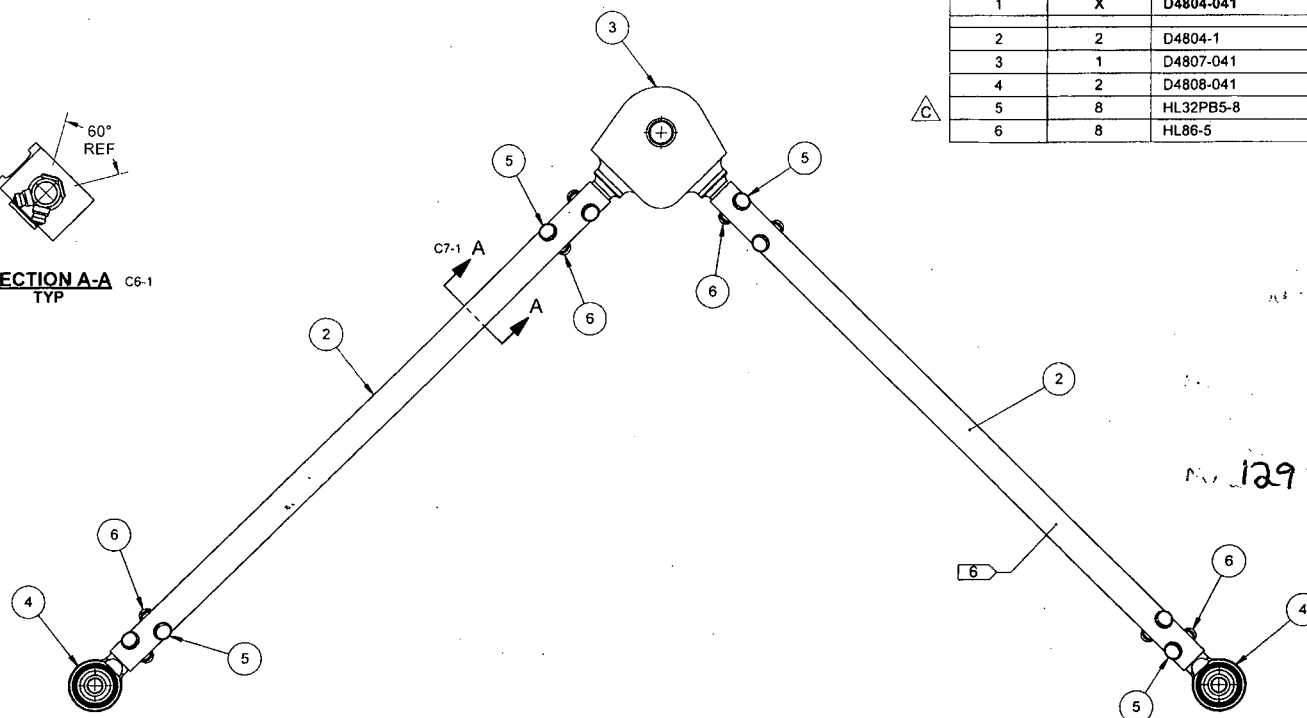
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SECTION A-A TYP C6-1



ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4804-041	BIPOD ASSEMBLY, AFT
2	2	D4804-1	STRUT
3	1	D4807-041	SUPPORT ASSEMBLY
4	2	D4808-041	ROD END BEARING ASSEMBLY
5	8	HL32PB5-8	HI-LOK PIN
6	8	HL86-5	HI-LOK COLLAR

129 783 MJS
1502-24

RELEASED
2014-07-07

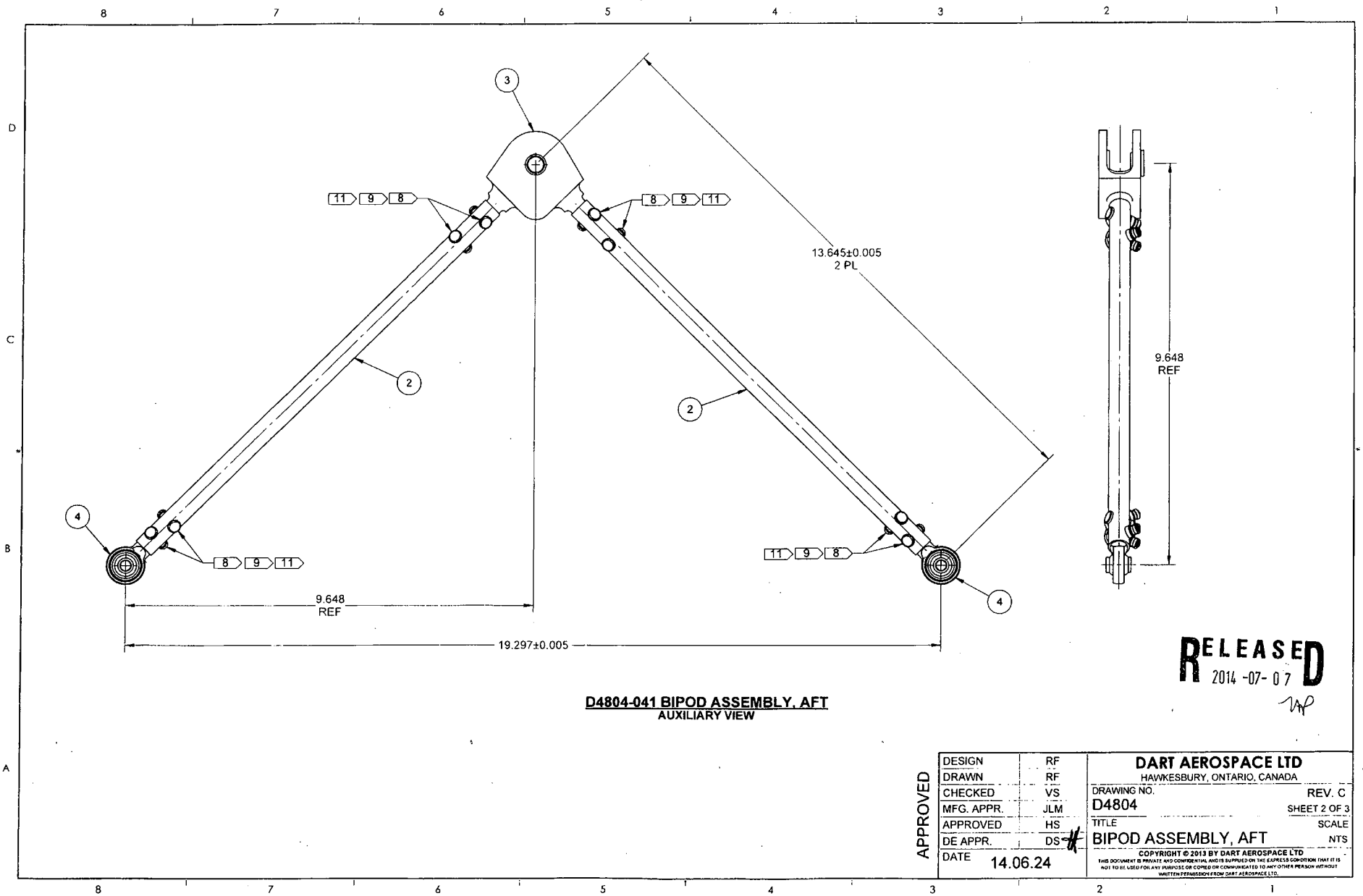
D4804-041 BIPOD ASSEMBLY, AFT
(EQUIVALENT TO BELL P/N 407-060-111-101)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 1.28 lbs
- 8) ALIGN PILOT HOLES IN D4807-041 WITH PILOT HOLES IN D4804-1.
ALIGN PILOT HOLES IN D4808-041 WITH PILOT HOLES IN D4804-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø 0.1610) REAMER, USING DART TOOL SETUP DT9954
- 9) INSTALL PIN/COLLAR AND ROD END WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9954
- 11) INSTALL HL32PB5-8 HI-LOK IN ORIENTATION SHOWN

C	HL32PB5-8 WAS HL20PB5-8 (ZN D4-1); REVISE NOTE 6) (ZN A8-3)	RF	14.06.24
B	REVISE NOTES 6), 7) & 9) (ZN A8-1); ADDED BELL P/N	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4804	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BIPOD ASSEMBLY, AFT	NTS
DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

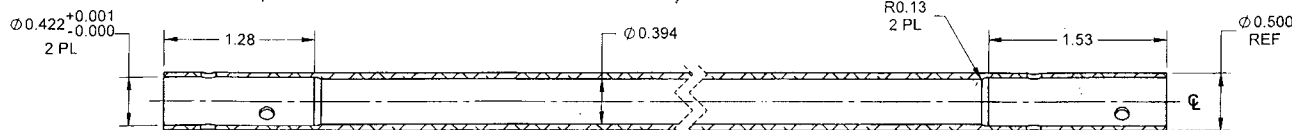
APPROVED



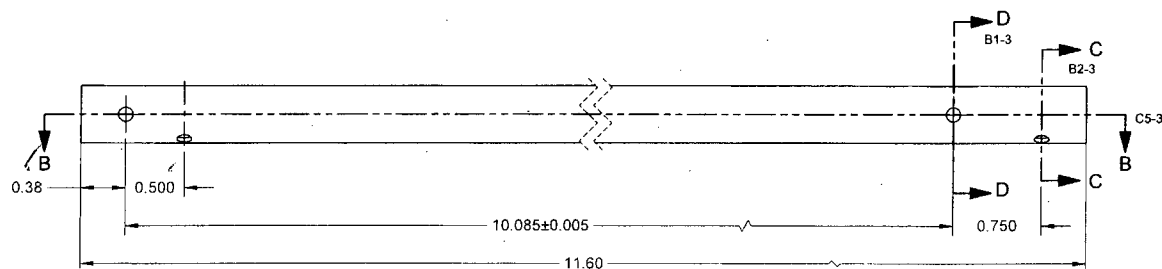
D4804-041 BIPOD ASSEMBLY, AFT
AUXILIARY VIEW

RELEASED
 2014-07-07
MP

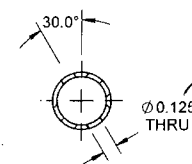
APPROVED	DESIGN	RF	DART AEROSPACE LTD	
	DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	VS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D4804	SHEET 2 OF 3
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	BIPOD ASSEMBLY, AFT	NTS
	DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



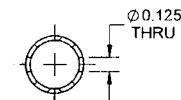
SECTION B-B B3-3



D4804-1 STRUT



**SECTION C-C C3-3
2 PL**



**SECTION D-D C4-3
2 PL**

NOTES:

- 1) MATERIAL: 17-4 PH/S174C0/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 0.23 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)



APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4804	REV. C
MFG. APPR.	JLM	SHEET 3 OF 3	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BIPOD ASSEMBLY, AFT	NTS
DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2014-07-07

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO24012	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 27868
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 2

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON:

ITEM ID: D4804-1 STUT WORK ORDER ID#: 129783

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE AS PER ASTM1417M-13						MAR 23 2015	
NO CRACK FOUND							
Pen: ZL-56 BATCH# 09H094 EXP. DATE: AUG 2014, DEV: SKD-S2 EXP. DATE: OCT2017 CLEANER: SKC-S EXP. DATE: APR 2018							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp: 16 53-89	Date:
Name: ANTONINO MARCHETTA		MAR 23 2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27868**

Purchase Order Date 3/23/2015

PO Print Date 3/24/2015

Page Number 2 of 2

Order From :

VC-SKY001

SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

905-678-5636

Ship To Contact

Ship To Phone

Ship Via:

Delivered

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

3	129783	D4804-1 STRUT	3/24/2015 Yes 3/24/2015	9.00	\$25.00	\$225.00
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Line Total: \$225.00

PO Total: \$655.00

CL

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Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 4

Change Date: 3/24/2015